

# Work Order ID 58913

May 19, 2010 2:21:16 PM



Page 1

Item ID: D3303-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 18.00

Customer:

Reference:

Approvals:

Process Plan:

*U*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3303

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D3303-02- Identify as D3303-043

*5/20/05/26* *(18)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*S 10/05/26*

*(18)*

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*112588*  
\*\*\*\*\*MASK THREADS PRIOR TO PAINT\*\*\*\*\*  
*8:30pm* START TIME: *9:00pm* FINISH TIME: *3:00pm*  
COVEN TEMPERATURE: *370°F*

*= 11 10/05/26*

*(18)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58913**

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Item ID: D3303-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

18 BR 10.5-28.

140 Identify as per dwg &amp; Stock Location: 186 0.00



Packaging Memo 0.00

Packaging

10/06/01 18

150 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/06/01 18

10-6-01 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1  
2

Work Order ID: 58913

Parent Item: D3303-043

Parent Item Name: Bracket Assembly









Comments: IPP: A ☐ 04.09.07 ☐ New Issue ☐ KJ/JLM ☐

Start Date: 5/19/10

Required Date: 5/25/10

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3303-1  Plate		Manufactured	No			100	Each	18.0000	1		5/10/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST185				18				
				54574				2				
				58349				16				
D3303-3  Bracket		Manufactured	No			100	Each	19.0000	1		5/10/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST185				19				
				58348				19				
MS20426AD3-3  Rivet		Purchased	No			100	Each	5,008.000	8		5/10/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST316				5008				
				19099				4774				
				7681				234				
MS20470AD4-4  Rivet, Universal Head		Purchased	No			100	Each	1,530.000	16		5/10/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST319				1530				
				112314				289				
				113368				1241				

M114761 (800)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 58913



Parent Item: D3303-043



Parent Item Name: Bracket Assembly

Start Date: 5/19/10

Required Date: 5/25/10

Comments: IPP: A ☐ 04.09.07 ☐ New Issue ☐ KJ/JLM ☐

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS21075L3

Purchased

No

100

Each

85.0000

4



Nutplate

*Handwritten signature and date: 5/10/05/26*

Location

Loc Qty

Loc Code

ST302

79

114449

79

ST303

6

113734

6

72

May 19, 2010 2:21:15 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

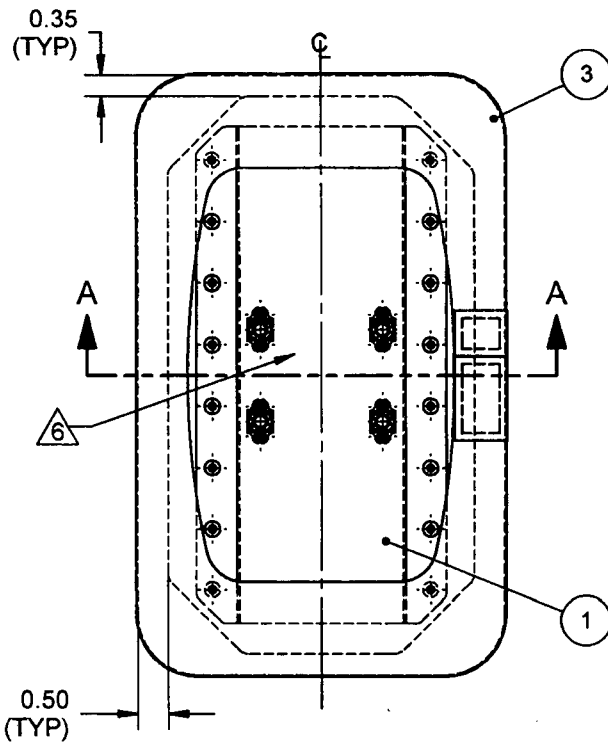
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



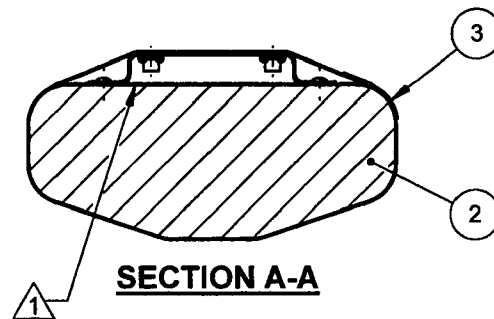


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17	TITLE HEAD REST SCALE 1:3		
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED  
dc-09.19 *[Signature]*

DEO ATTACHED



*W058013*

### D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

#### NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

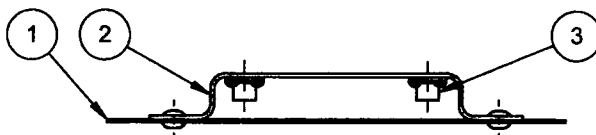
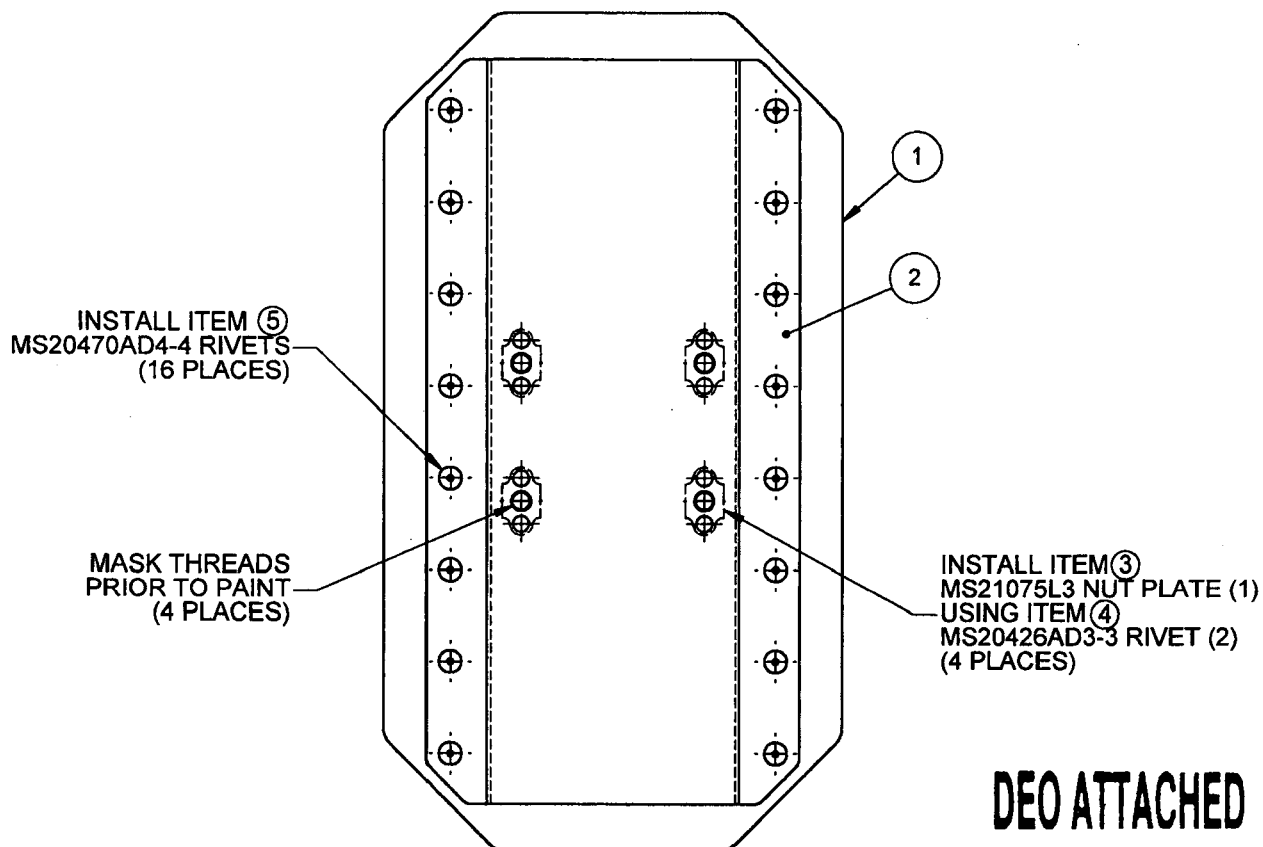
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



### D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

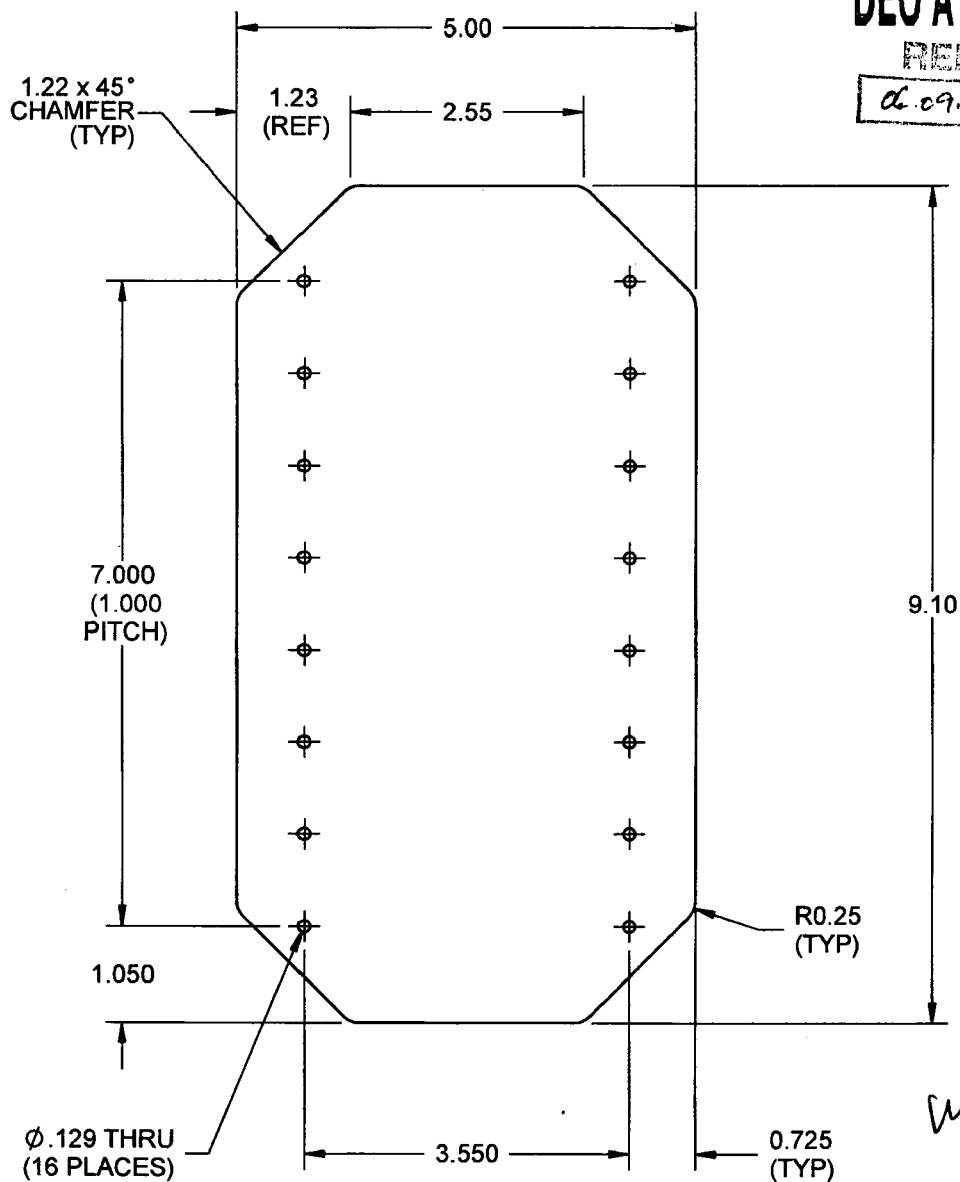
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. <b>D3303</b>
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	REV. B SHEET 3 OF 4 SCALE 1:2



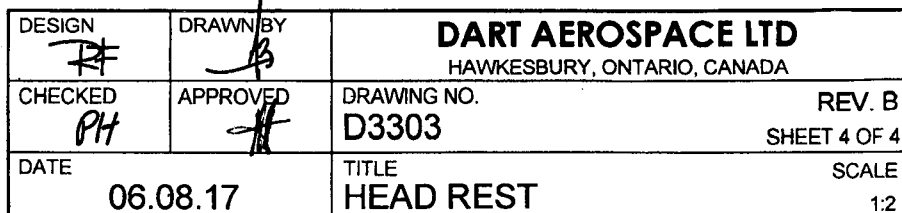
### **D3303-1 PLATE**

#### **NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

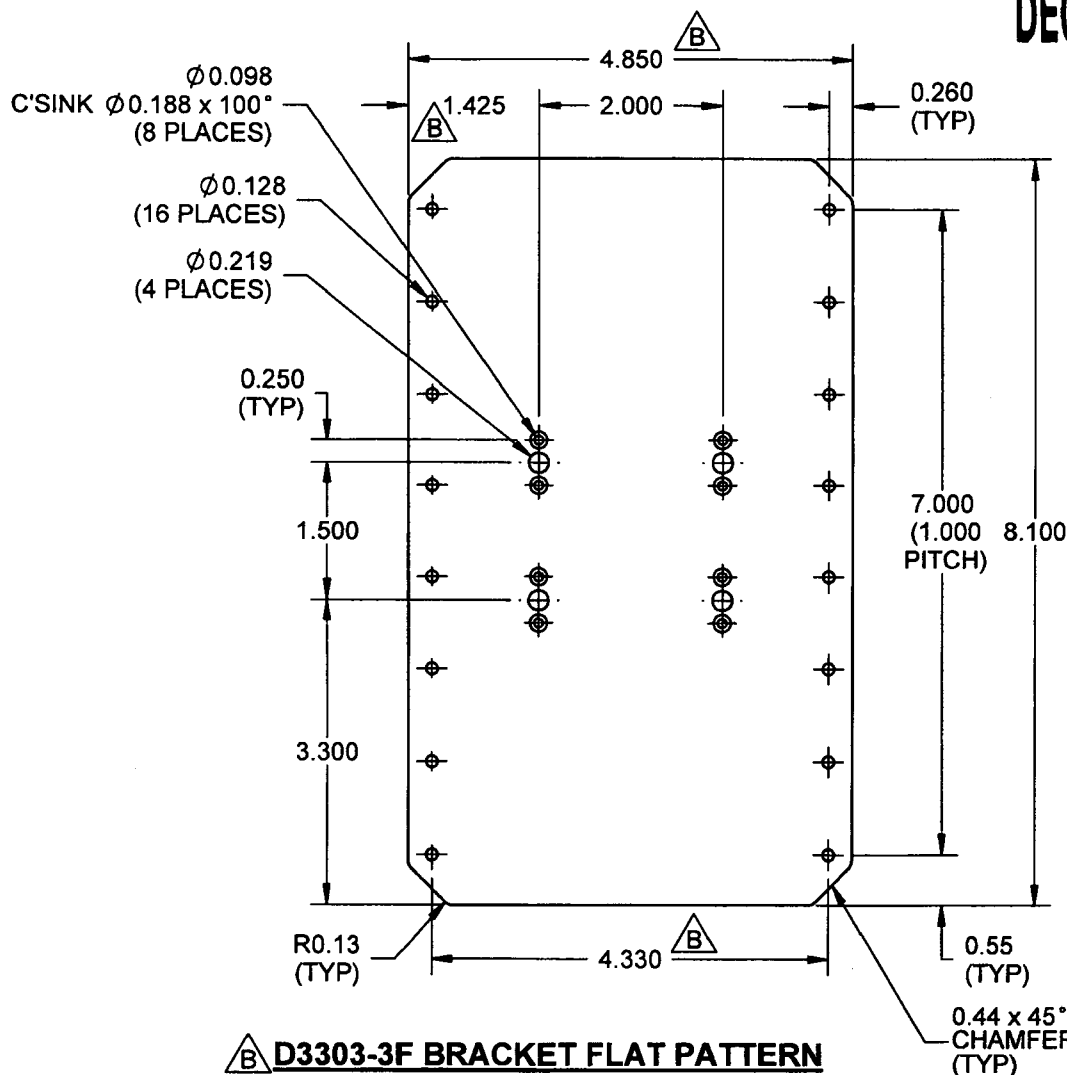
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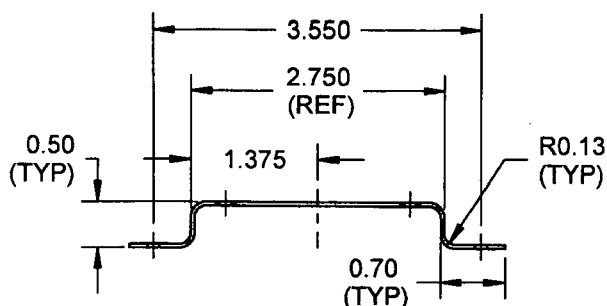


SECRET

06-09-19



Wb 58912



### **D3303-3 BRACKET BEND DETAIL**

**NOTES:**

- NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET  
(REF. DART SPEC. M2024T3S.040)
  - 2) FINISH: CHEMICAL CONVERSION COAT AS PER  
DART QSI 005.4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE  
NOTED
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DRAWING NO. D3303	TITLE HEAD REST	REV. B	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3303-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>		DE APPR. <i>h</i>		
DATE 08.10.15	DATE 08.10.15	DATE 08/10/16	DATE 08/10/16		DATE 08/10/16		

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

**IS:**

**NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

**WAS:**

**NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SEE NCR 08-069 FOR FURTHER DETAILS

*John S. 8/13*

**RELEASED**  
08/11/16